

Work Order ID 62989

Friday, October 15, 2010 9:22:53 AM



Page 1

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 10/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: ✓Date: 10-10-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c/sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: 11585

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

SAA 10-10-19② Cpl 10-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62989

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Page 2

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 10/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

0.00

2

10/10/20

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2

10/10/20

150



Packaging

Packaging

Identify as per dwg & Stock Location: *CWA*

0.00

Memo

0.00

SAD
*10-10-20**(2)*

W/O:		WORK ORDER CHANGES					
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Work Order ID 62989


Friday, October 15, 2010 9:22:53 AM

Page 3

Item ID: D3852-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib Assembly
Start Date: 10/15/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 10/21/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/10/20 MF
10-10-20

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, October 15, 2010 9:22:57 AM

Page 1

Work Order ID: 62989



Parent Item: D3852-042



Parent Item Name: Rib Assembly

Start Date: 10/15/2010

Required Date: 10/21/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3		Manufactured	No			100	Each	6.5334	0.18	0.378947			
Basket Hoop													

Location	Loc Qty	Loc Code
WA	6.533371053	
55697	2.1053E-05	
59266	0.0418	
60270	0.49155	
61193	6	

SAD 10-10-19

0.3289

D3759-1		Manufactured	No			100	Each	72.0000	1	2			
Bushing													

Location	Loc Qty	Loc Code
ST084	21	
56942	21	
WA	51	
54072	9	
61379	42	

CP 10-10-19

2

W/O:		WORK ORDER CHANGES					
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62989

PS 10-10-15

RELEASE
08/11/18 MJP

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs EACH
8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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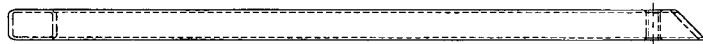
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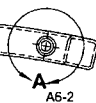
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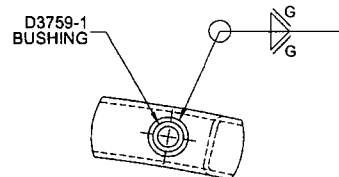
NOTE: Date & initial all entries



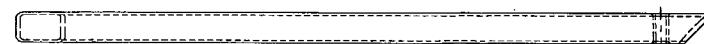
D3852-1
RIB



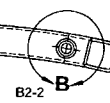
D3852-041 RIB ASSEMBLY



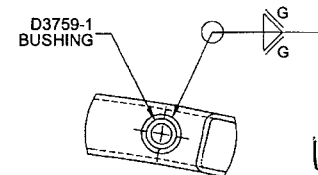
DETAIL A
SCALE 2X C5-2



D3852-2
RIB



D3852-042 RIB ASSEMBLY



DETAIL B
SCALE 2X C2-2

WLO 62989

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>125</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>125</i>	D3852	SHEET 2 OF 3
APPROVED	<i>125</i>	TITLE	SCALE
DE APPR.	<i>125</i>	RIB ASSEMBLY	NTS
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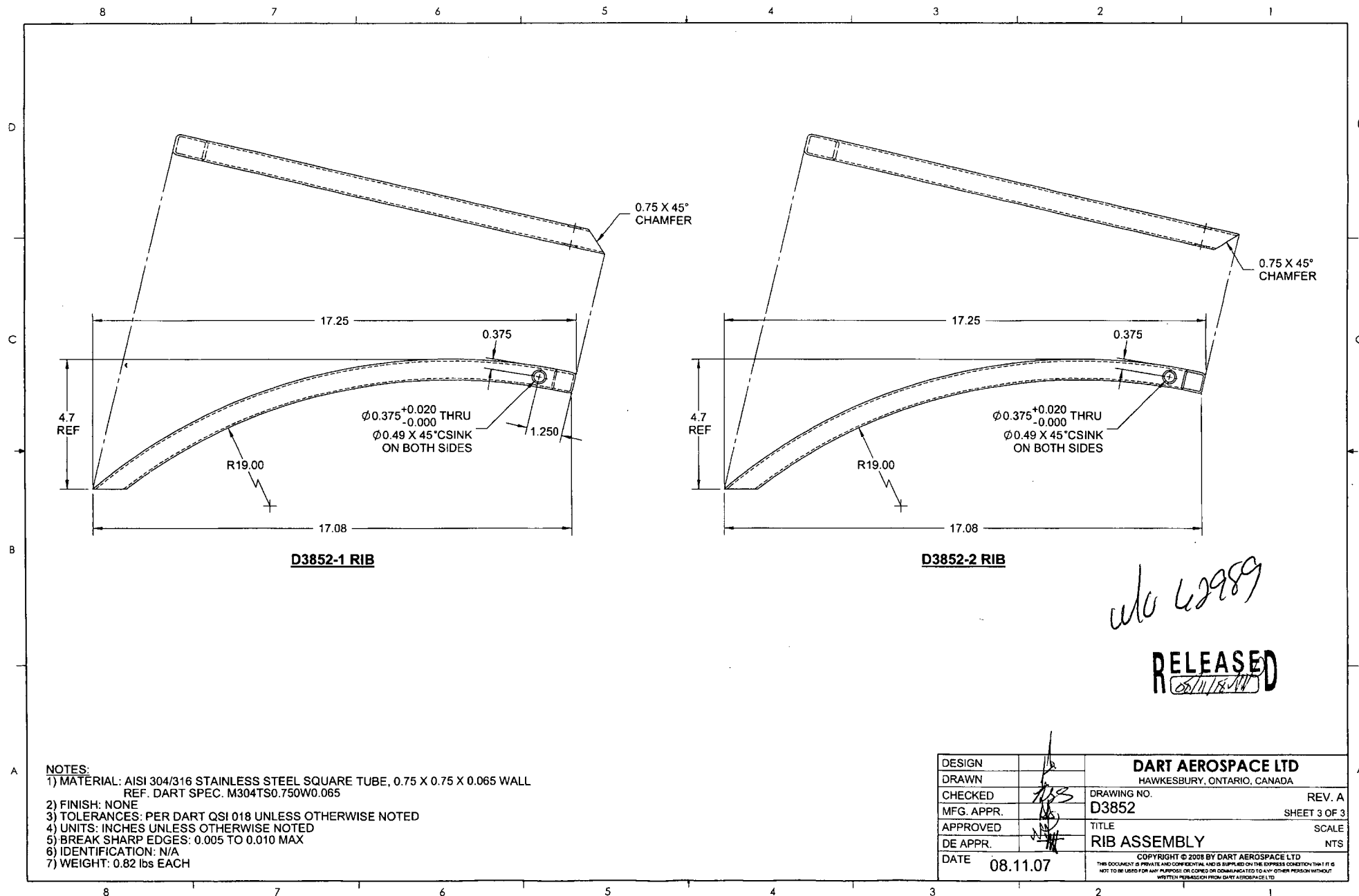
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3852	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
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